

# Work Order ID 73931

Monday, September 19, 2011 12:51:58 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: *10-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

*Swlulic*

*Off for MLS 11-11-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	<b>Memo</b> 1- Pick D2600-3 Bent  2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750  3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.  4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting  5- Drill only two fwd step holes using DT9616. Ensure proper positioning.  6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)  7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***  8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)  9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".  10- Open up holes of Detail A to 0.297" (total of 2 holes per side)	0.00							

11/11/01

**Dart Aerospace Ltd**

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Page 3

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M118736

BE 11/11/01

12-Grind welds flush as per Dwg D2750

BE 11/11/01

KE 11-11-01

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

1 0

130



QC

Quality Control

QC5- Inspect part completeness to step-on W/O

0.00

Memo

0.00

11 11-11-01 1

W/O:		WORK ORDER CHANGES					
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Page 4

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

① SAO 11-11-01

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 11-11-3

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**Work Order ID 73931**

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Page 5

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	<p><b>Memo</b></p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3-Open float holes to .500" (4 per Side)</p> <p>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6-Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: <u>119399</u> <input type="checkbox"/><input type="checkbox"/> exp. date: <u>12/08/13</u>.</p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: <u>M118736</u> BE <u>11/11/07</u></p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404" BE <u>11/11/07</u></p> <p>10-Grind welds flush as per Dwg D2750</p> <p>11-Spot face ground handling holes section (total of 4 places per side) as per</p>								

11/11/08

11/11/08

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Monday, September 19, 2011 12:51:58 PM



Page 6

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

dwg D2750

12-Deburr holes

3/11/11/08

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sululog

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sululog

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Monday, September 19, 2011 12:51:58 PM



Page 7

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	Memo 0.00				1	BK	11-11-9.	
	Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.							
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	Memo 0.00							
	Powder Coating	START TIME: 10:30 OVEN TEMPERATURE: 320 FINISH TIME: 11:00							
210	QC3- Inspect Part Finish	0.00							
	QC	Memo 0.00				1	BK	11-11-10.	
	Quality Control	Inspect for foreign object per QSI 024							

KJ M-11/11/10

1 BK 11-11-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, September 19, 2011 12:51:58 PM



Page 8

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230



HandFinish

HandFinishing

0.00

Hand Finishing

Memo

0.00

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"  
batch: W/A.4-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750  
SIKA FLEX 241BATCH: 119443.EXP DATE: 2012-15.5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 110348.6-Coat all exposed fasteners with "LPS Procyon"  
batch: 114546.1 11-11-11.

**Dart Aerospace Ltd**

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Monday, September 19, 2011 12:51:58 PM



Page 9

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Sp 11-11-14

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

(X)

W/O:		WORK ORDER CHANGES					
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Monday, September 19, 2011 12:51:58 PM



Page 10

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

**Dart Aerospace Ltd**

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# Picklist Print

Monday, September 19, 2011 12:52:17 PM

Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per  
 IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225		Purchased	No				Each	1,883.000		38			
Insert													

Location	Loc Qty	Loc Code
ST282 118966	1883	
110768	62	
117717	9	
118386	860	
118696 ✓	952	

AN3C5A		Purchased	No			230	Each	1,062.000	34	34			
Bolt													

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1055	
116419	28	
117343	356	
117764	169	
117872	2	
118451 ✓	500	

BL 11-11-11.

BL 11-11-11.

24.

14

34.

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Monday, September 19, 2011 12:52:17 PM

Page 2

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Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

288.0000

4

4



BOLT



BP 11-11-11

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

287

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

37

118422 ✓

200

AN6C44A

Purchased

No

230

Each

83.0000

4

4



BOLT



BP 11-11-11

Location

Loc Qty

Loc Code

FG

2

119530.  
103964

2

ST344

81

118332

31

118387

50

Monday, September 19, 2011 12:52:18 PM

Shop Packet Print

Page 2

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, September 19, 2011 12:52:18 PM

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

123.0000

1

1



BOLT



BR 11-11-11

Location

Loc Qty

Loc Code

FP

87

117511

21

118286 ✓

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

\*

NAS1149C0332 ✓

Purchased

No

230

Each

0.0000

38

38



118354



38. BR 11-11-11

washer

D2745

Manufactured

No

230

Each

245.0000

8

8



BR 11-11-11

Bushing

Location

Loc Qty

Loc Code

FP-A

83

69529

83

ST023

162

71835 ✓

162

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:18 PM

Page 4

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

25.0000

1

1



Blade Fitting Assembly, RH



BR 11-11-11

Location

Loc Qty

Loc Code

FP008

25

62003

1

68109

4

69904

9

71883

11

D3492-1

Manufactured No

230

Each

8.0000

8

8



Plug



BR 11-11-11

Location

Loc Qty

Loc Code

FP

74444

8

69531

8

D3492-3

Manufactured No

230

Each

109.0000

8

8



Plug



BR 11-11-11

Location

Loc Qty

Loc Code

FP

74871

109

71838

100

72126

9

D3535-25

Manufactured No

230

Each

9.0000

1

1



Wearshoe



BR 11-11-11

Location

Loc Qty

Loc Code

FP018

74525

9

62233

1

69743

8

Monday, September 19, 2011 12:52:18 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B /			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:18 PM

Page 5

Work Order ID: 73931



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

12.0000

1

1



Gasket



BR 11-11-11

Location

Loc Qty

Loc Code

FP012

74595

12

1

70780

12

D3537-1

Manufactured No

230

Each

70.0000

3

3



BR 11-11-11

Wearpad

Location

Loc Qty

Loc Code

FP001

74436

60

3

72124

60

FP016

3

68944

0

70687

3

FP017

7

69817

5

70686

2

D3631-1

Manufactured No

230

Each

187.0000

8

8



BR 11-11-11

Washer

Location

Loc Qty

Loc Code

ST072

187

68062

187

8

Monday, September 19, 2011 12:52:18 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:19 PM

Page 6

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1  
Wearplate

Manufactured No

230

Each

19.0000

1

1

BR 11-11-11

Location

Loc Qty

Loc Code

FP017 74507 7

62239 2

69282 5

FP17 - 12

72158 12

D3793-1  
Wearshoe

Manufactured No

230

Each

11.0000

1

1

BR 11-11-11

Location

Loc Qty

Loc Code

FP018 74591 11

70781 11

D3793-3  
Wearshoe

Manufactured No

230

Each

17.0000

1

1

BR 11-11-11

Location

Loc Qty

Loc Code

FP018 74508 17

70813 5

72160 12

D3794-1  
Gasket

Manufactured No

230

Each

17.0000

1

1

BR 11-11-11

Location

Loc Qty

Loc Code

FP010 74509 17

70779 17

Monday, September 19, 2011 12:52:19 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, September 19, 2011 12:52:19 PM

Page 7

Work Order ID: 73931



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

8.0000

1

1



Gasket



PR 11-11-11.

Location

Loc Qty

Loc Code

FP018

74530  
70812

8

8

MS21043-6

Purchased

No

230

Each

545.0000

4

4



PR 11-11-11.

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

525

112314 ✓

315

117887

10

118384

200

MS21083C8

Purchased

No

230

Each

97.0000

1

1



PR 11-11-11.

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

22

118077

22

ST303

74

115884

0

118354

24

118614 ✓

50

1

Monday, September 19, 2011 12:52:19 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:19 PM

Page 8

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

356.0000

1

1



WASHER



BR 11-11-11.

Location

Loc Qty

Loc Code

FP-B

27

114915 ✓

27

ST297

329

114915

329

NAS1515H3L

Purchased

No

230

Each

180.0000

4

4



WASHER



BR 11-11-11.

Location

Loc Qty

Loc Code

FG

40

102472 ✓

40

ST277

140

113362 ✓

57

118686

83

NAS1611-010

Purchased

No

230

Each

175.0000

8

8



O-RING



BR 11-11-11.

Location

Loc Qty

Loc Code

FP

161

119438 ✓

117460

8

118077

1

118612

152

FP-A

14

110915

14

8.

Monday, September 19, 2011 12:52:19 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:19 PM

Page 9

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

172.0000

8

8



O-RING



BL 11-11-11

Location

Loc Qty

Loc Code

FP

119438.

55

117291

2

117887

53

FP-A

117

116582

5

118384

112

8.

AN8C21A

Purchased

No

250

Each

93.0000

2

2



BOLT



SP

Location

Loc Qty

Loc Code

ST345

93

118045

43

118758

50

Manufactured

No

250

Each

39.0000

1

1

D2741



Blade, 350 Skidtube



2x

SP

Location

Loc Qty

Loc Code

ST466

39

69133

1

70667

38

Manufactured

No

250

Each

73.0000

2

2

D3493-1



Washer



1x

SP

Location

Loc Qty

Loc Code

ST062

73

70697

33

71846

40

2x

Monday, September 19, 2011 12:52:19 PM

Shop Packet Print

Page 9

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:19 PM

Page 10

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3532-1  
Spacer  
Manufactured No

250 Each 15.0000



2  
B73342. Sp 11-11-14

Location Loc Qty Loc Code

ST065 15  
69895 15

MS21083C8  
NUT  
Purchased No

250 Each 97.0000



2  
m 119309 2x SP

Location Loc Qty Loc Code

FP-B 1  
115884 1  
ST293 22  
118077 22  
ST303 74  
115884 0  
118354 24  
118614 50

NAS1149D0863J  
WASHER  
Purchased No

250 Each 152.0000



2  
SP

Location Loc Qty Loc Code

ST298 152  
118078 152

D2600-3-BENT  
Extrusion Bent  
Manufactured No

110 Each 9.0000



2x  
1

Location Loc Qty Loc Code

LG 9  
66875 8  
72153 1

(1) B 11/11/01

Monday, September 19, 2011 12:52:20 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, September 19, 2011 12:52:20 PM

Page 11

Work Order ID: 73931

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

73.0000

1

1



Cap



*BE 11/10/11*

Location

Loc Qty

Loc Code

LG002

17

62715

1

70881

16

WA

56

71861

56

D2739

Manufactured No

160

Each

9.0000

1

1



350 I Beam



*(1) B 11/11/08*

Location

Loc Qty

Loc Code

LG

9

70823

1

72154

4

72155

4

D2743

Manufactured No

160

Each

166.0000

8

8



Crossbolt Spacer



*BE 11/11/07*

Location

Loc Qty

Loc Code

LG

108

69818

5

71839

103

LG001

58

67766

4

68251

54

*8*

Monday, September 19, 2011 12:52:20 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, September 19, 2011 12:52:20 PM

Page 12

Work Order ID: 73931



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160

Each

10.0000

4

4



Cross Bolt Spacer



BE11/11/07  
B 73295 x4

Location

Loc Qty

Loc Code

LG

10

70768

10

D3490-1 Manufactured No

160

Each

82.0000

4

4



Cross Bolt Spacer



BE11/11/07

Location

Loc Qty

Loc Code

LG

80

67773

5

69823

10

71841

65

LG001

2

62450

2

4

Monday, September 19, 2011 12:52:20 PM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 13931  
P11-09-19

RELEASED  
68 09 22 14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 1 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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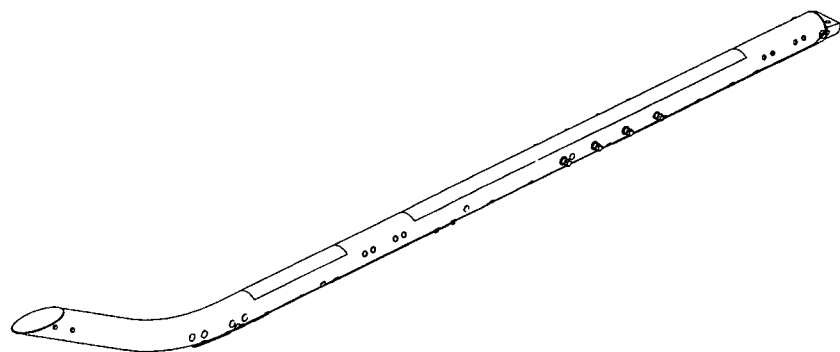
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

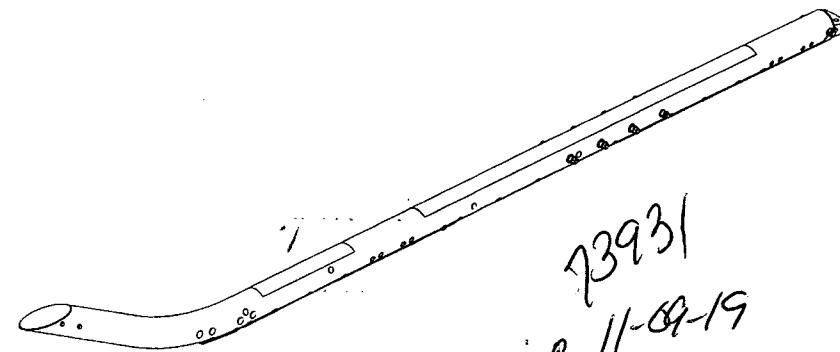
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
15-09-22-11-14

DESIGN	PM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	LA	DRAWING NO.	REV. F
MFG. APPR.	LA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

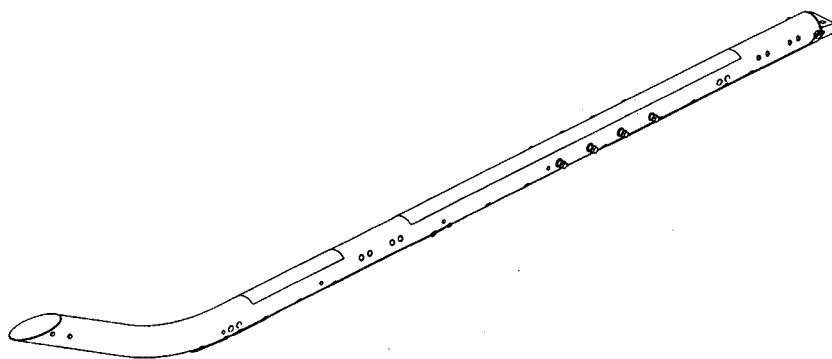
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

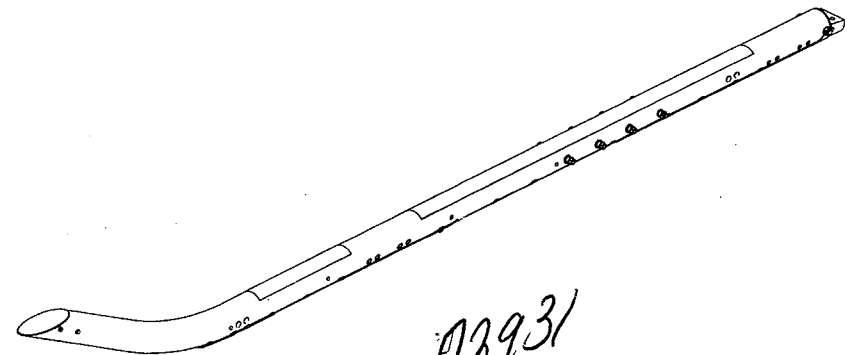
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-09-22/11

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

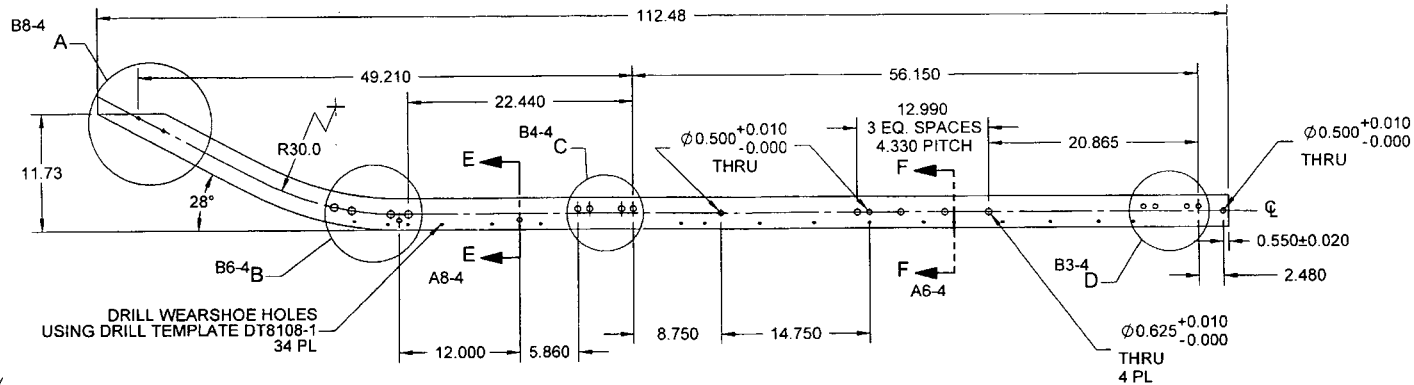
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

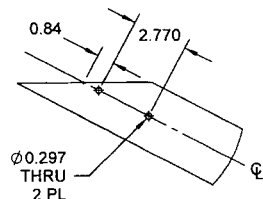
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

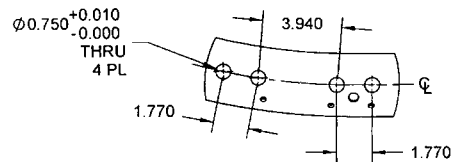
**NOTE:** Date & initial all entries



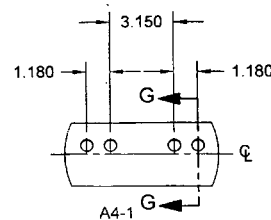
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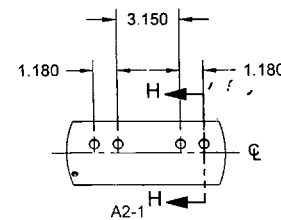
**DETAIL A**  
SCALE 2X



**DETAIL B**  
SCALE 2X



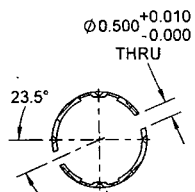
**DETAIL C**  
SCALE 2X



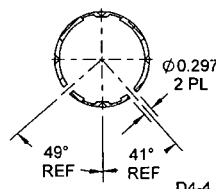
**DETAIL D**  
SCALE 2X

73931

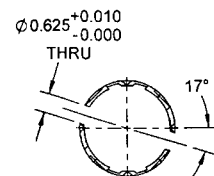
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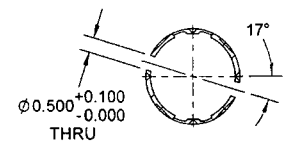
**SECTION E-E**  
SCALE 3X, 2 PL






**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

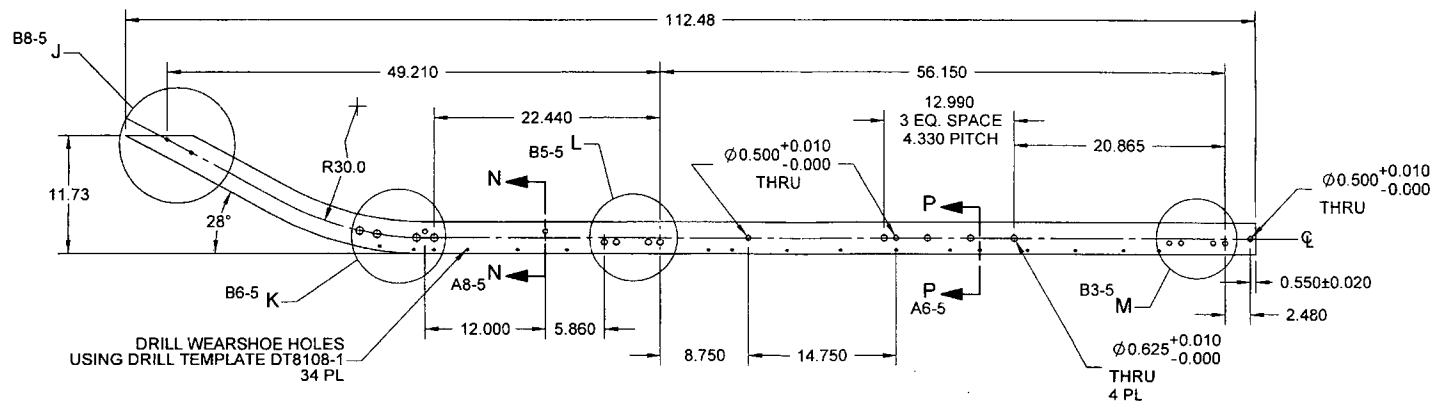
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

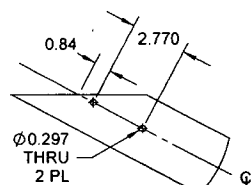
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

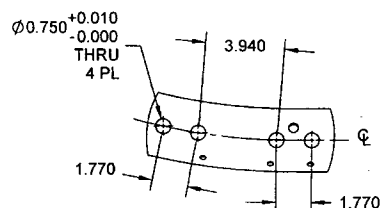
**NOTE:** Date & initial all entries



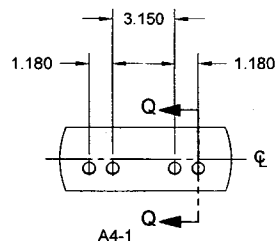
**D2750-2 RH SKIDTUBE**



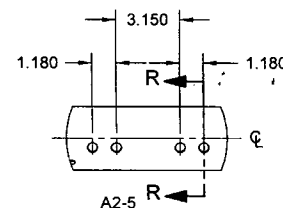
**DETAIL J**  
SCALE 2X



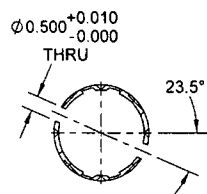
**DETAIL K**  
SCALE 2X



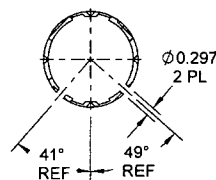
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SCALE 2X



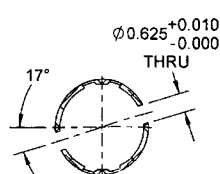
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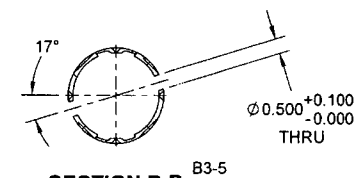
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DESIGN	PL	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PL	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

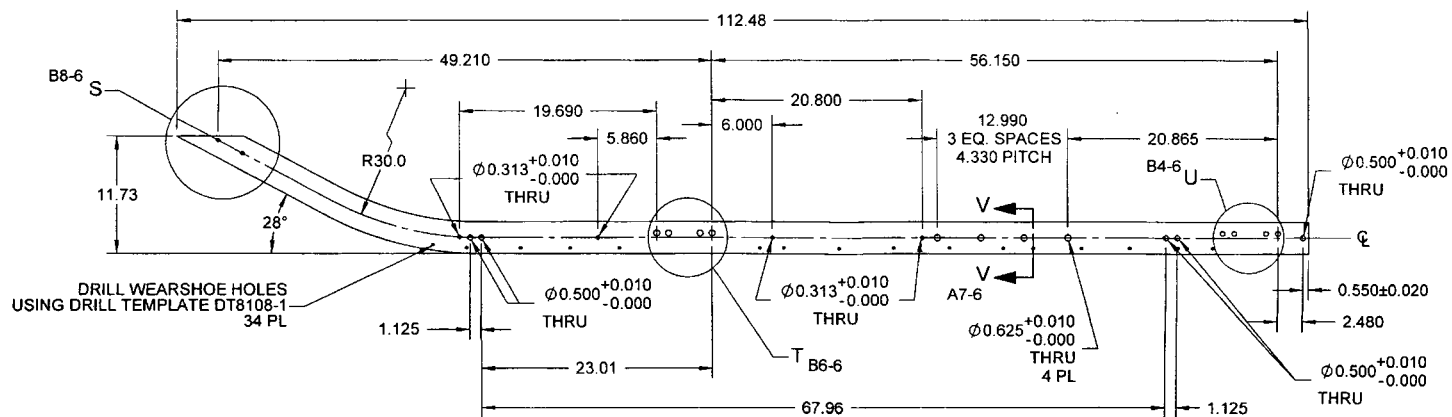
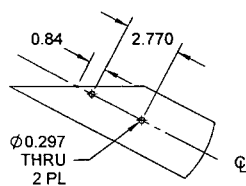
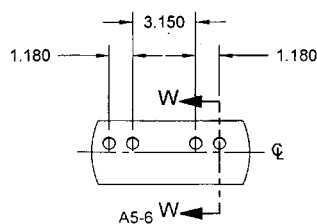
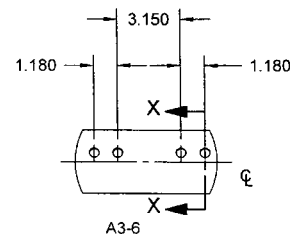
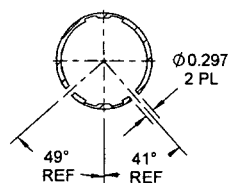
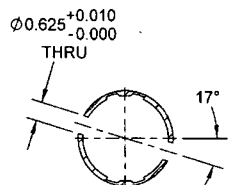
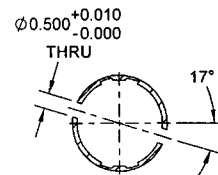
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4

3

2

1

**D2750-3 LH SKIDTUBE****DETAIL S**  
SCALE 2X**DETAIL T**  
SCALE 2X**DETAIL U**  
SCALE 2X**SECTION V-V**  
SCALE 3X, 17 PL**SECTION W-W**  
SCALE 3X, 4 PL**SECTION X-X**  
SCALE 3X, 4 PL

43931

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

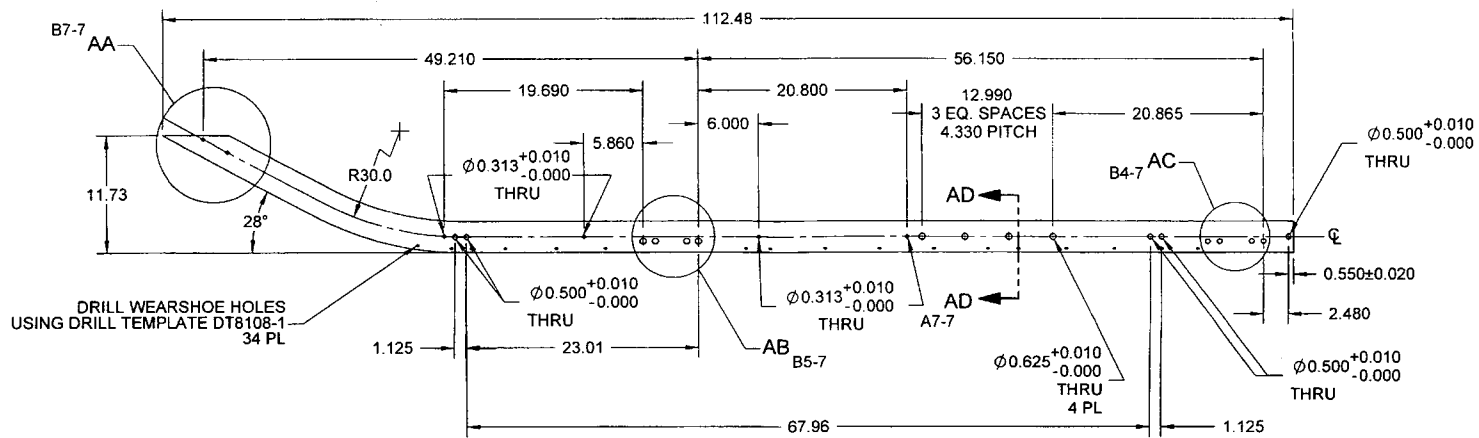
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

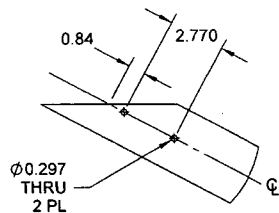
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

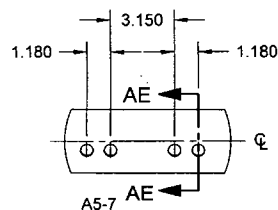




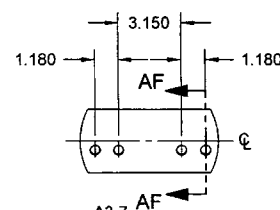
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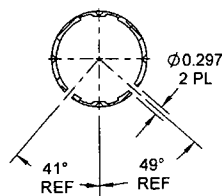
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SCALE 2X



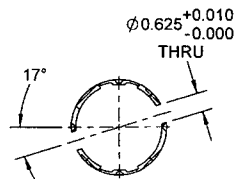
**DETAIL AB**  
SCALE 2X



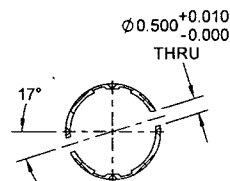
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

73931

**RELEASED**

DESIGN	pg	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	pg	PORT HADLOCK, WA	
CHECKED	pg	DRAWING NO.	REV. F
MFG. APPR.	pg	D2750	SHEET 7 OF 11
APPROVED	pg	TITLE	SCALE
DE APPR.	pg	350 SKIDTUBE ASSEMBLY	NTS
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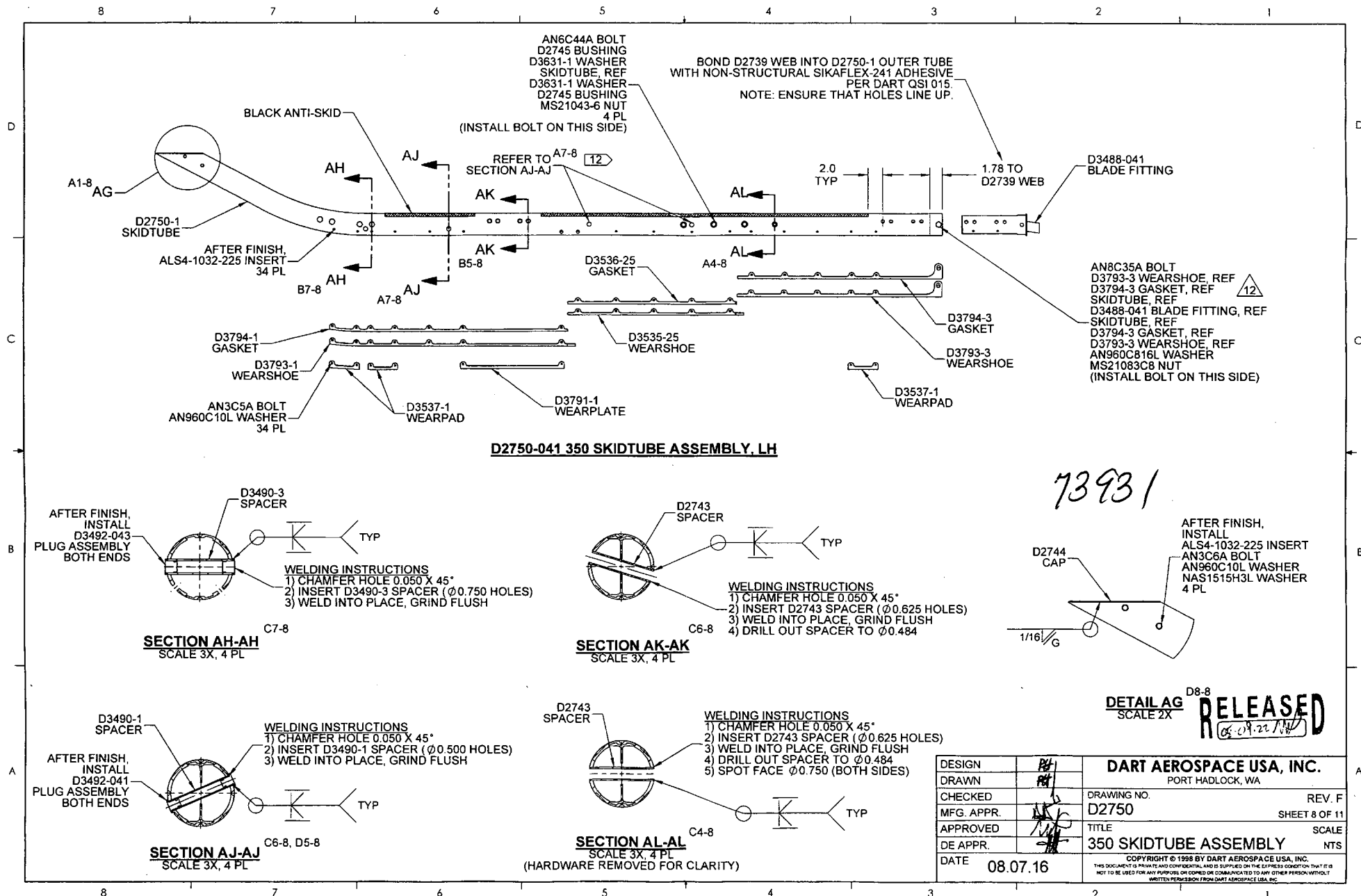
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

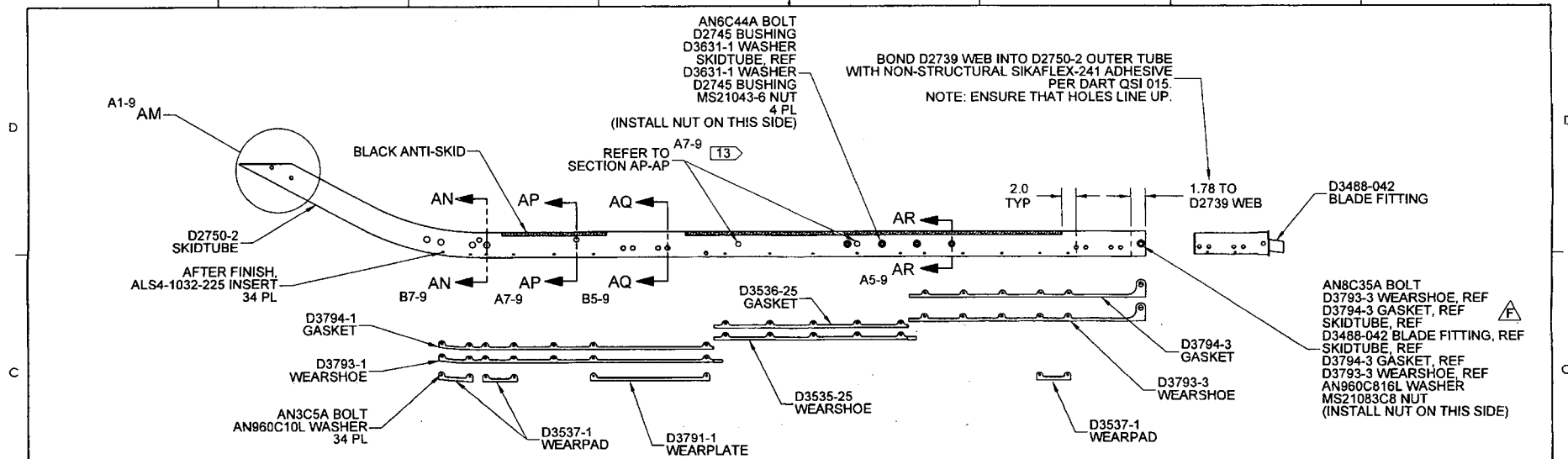
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

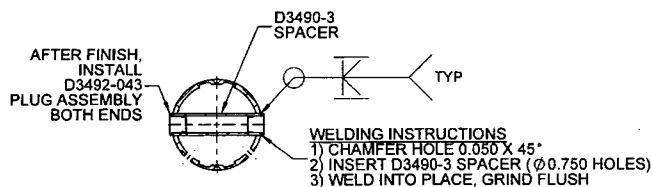
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

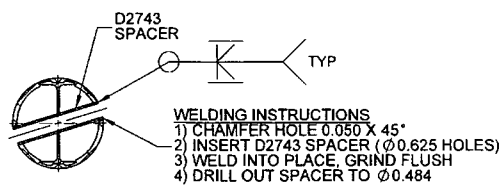
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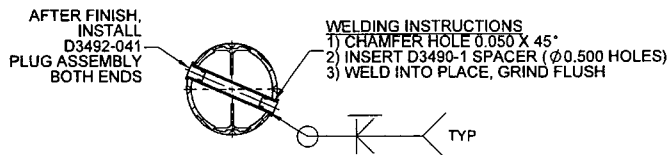
# **D2750-042 350 SKIDTUBE ASSEMBLY, RH**



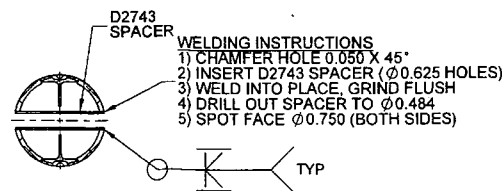
## **SECTION AN-AN** SCALE 3X, 4 PL



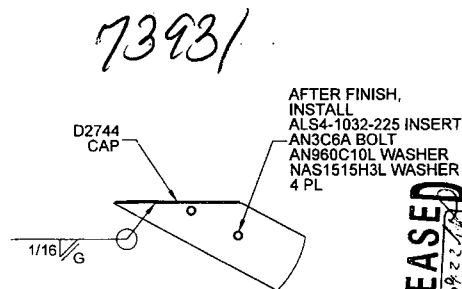
## **SECTION AQ-AQ** SCALE 3X, 4 PL



## **SECTION AP-AP** SCALE 3X, 4 PL



## **SECTION AR-AR** SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



## **DETAIL AM** SCALE 2X

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	MD	TITLE	SHEET 9 OF 11
APPROVED	MD	<b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.	MD		NTS
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RELEASED  
2022

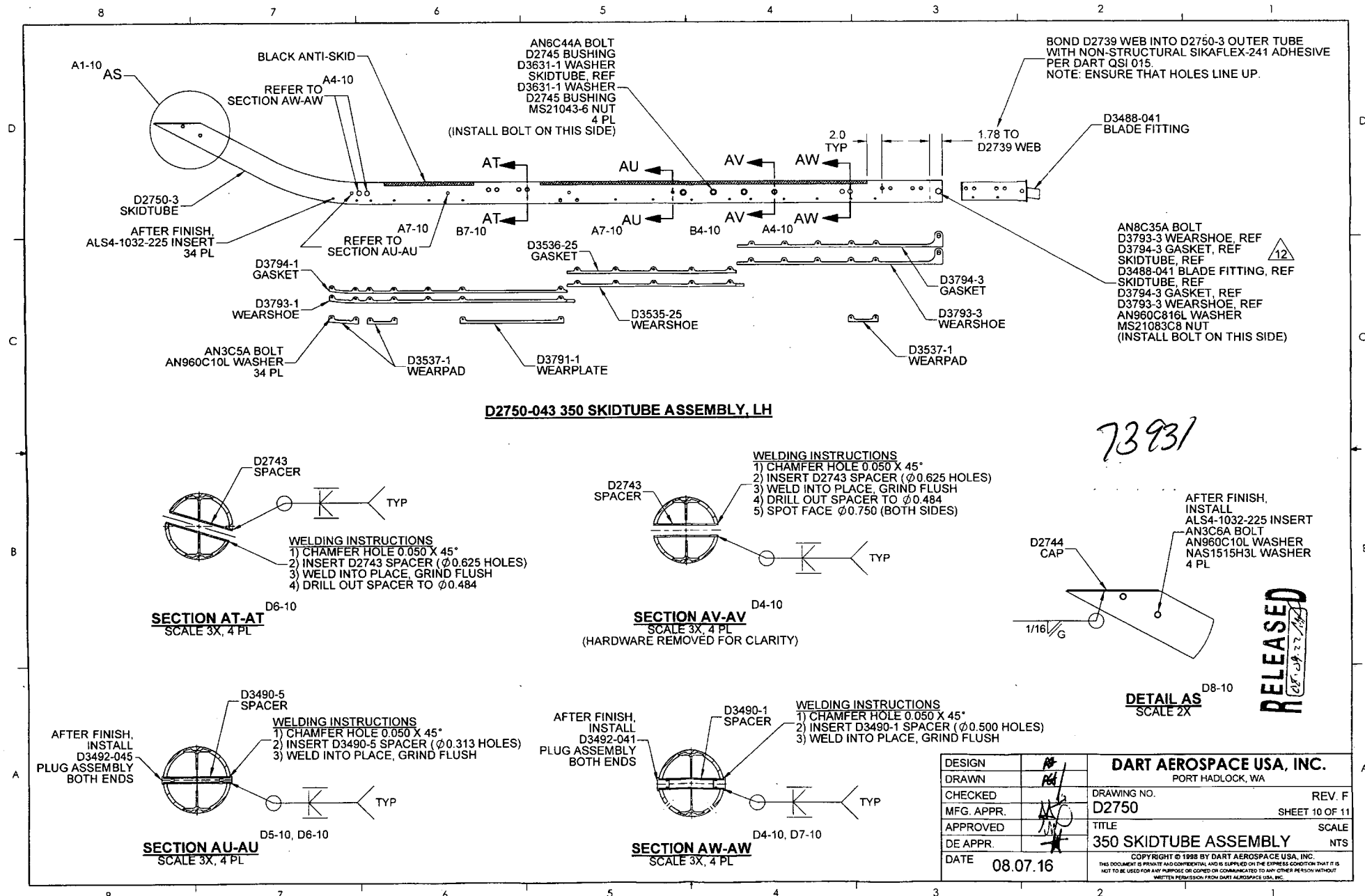
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

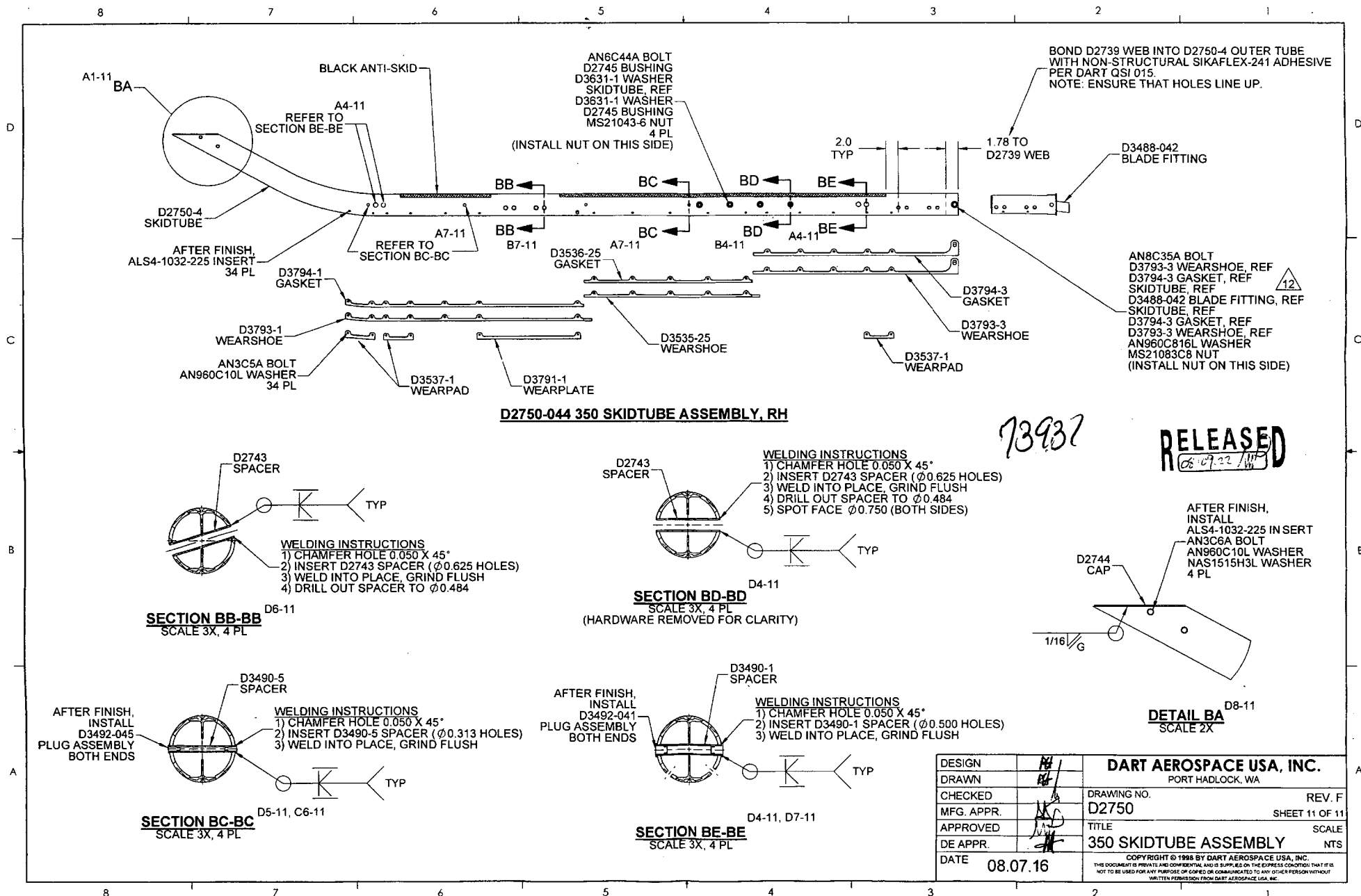
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 270

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B 72821  
Part number: D 350 636 D12  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lums Date of Test Coupon 11-10-07

Welder Barclay Elliott Date of Test Coupon 11-10-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld